

Date: Monday, 07/01/2008 10:52:50 AM  
 User: Linda Lacelle

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: BOLT		
Job Number	: 36608		Part Number	: D312121		
Estimate Number	: 10372		Drawing Number	: D3121 REV E		
P.O. Number	: N/A		Project Number	: N/A		
This Issue	: 07/01/2008 S.O. No. : N/A		Drawing Revision	: E		
Prsht Rev.	: NC		Material	: N/A		
First Issue	: N/A		Due Date	: 14/01/2008 Qty: 60 Um: Each		
Previous Run	: 34522					
Written By	: <u>Linda Lacelle</u>					
Checked & Approved By	: <u>Linda Lacelle</u>					
Comment	: Est. A04.02.09 New issue KJ/DS Est Rev:B ECN 1060 07-11-12 DD verified by:EC					

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M303H0500	303 HEX BAR
<b>Comment:</b> Qty.: 0.0417 f(s)/Unit Total : 2.5020 f(s) 303 HEX BAR Material: AISI 303 SS 1/2" Hex Bar (M303H0.500) Batch: M106789		
		J.F. 08/01/12
2.0	HARDINGE	HARDINGE CNC LATHE SMALL
<b>Comment:</b> HARDINGE CNC LATHE SMALL 1-Turn D3121-21 2-Identify as D3121-21 3-Deburr break all sharp edges 0.005" to 0.010"		
		J.F. 08/01/12 (60)
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
<b>Comment:</b> INSPECT PARTS AS THEY COME OFF MACHINE		
		J.F. 08/01/12 (60)
4.0	QC8	SECOND CHECK
<b>Comment:</b> SECOND CHECK		
		J.F. 08/01/13 (60)
5.0	PACKAGING 1	PACKAGING RESOURCE #1
<b>Comment:</b> PACKAGING RESOURCE #1 Identify and Stock Location: 66		
		J.F. 08/01/17 (60)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes  No  DQA:  Date: 08/01/14  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BOLT

Job Number: 36608

Part Number: D312121

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 QC21

FINAL INSPECTION/W/O RELEASE



(60)

Comment: FINAL INSPECTION/W/O RELEASE

Do 01/01/14

Job Completion



U 08.01.14

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

<b>DART AEROSPACE LTD</b>	<b>Work Order:</b>	<i>3108</i>
<b>Description:</b> Bolt	<b>Part Number:</b>	<b>D3121-21</b>
<b>Inspection Dwg:</b> D3121	<b>Rev:</b> D	<b>Page 1 of 1</b>

# FIRST ARTICLE INSPECTION CHECKLIST

## X First Article      Prototype

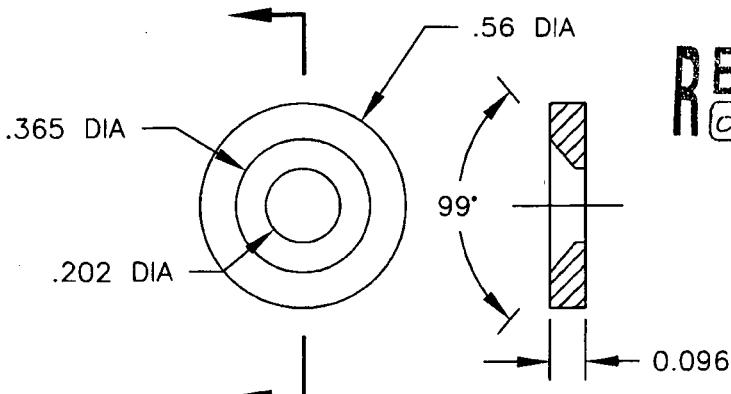
Measured by:	J.F.	Audited by:	S.A.	Prototype Approval:	N/A
Date:	08/01/13	Date:	08/01/13	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.02.27	New Issue	KJ/RF	
B	06.03.09	Dwg Rev. updated	KJ/JLM	
C	06.06.14	Dwg Rev. updated	KJ/JLM	

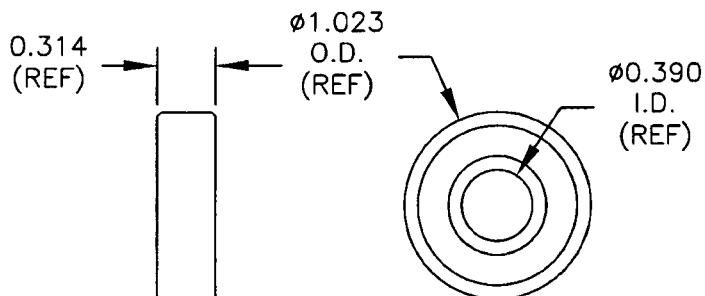
**DART**

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.	REV. E
		D3121	SHEET 10 OF 10
DATE	TITLE	SCALE	1:1

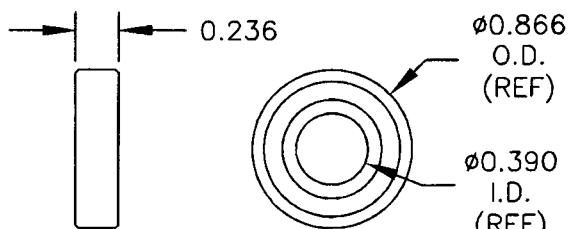
07.11.07      BRACKET ASSEMBLY

**D3121-17 WASHER (SCALE 2:1)**

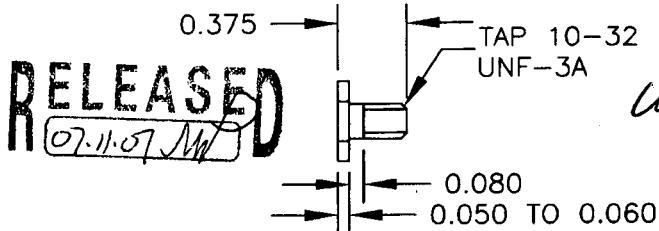
- 1) REPLACES PREMIER P/N B32-23001-17
- 2) MATERIAL: AISI 303 SS ROUND BAR, ANNEALED (REF DART SPEC. M303R)
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015

**D3121-19 BEARING (SCALE 1:1)**

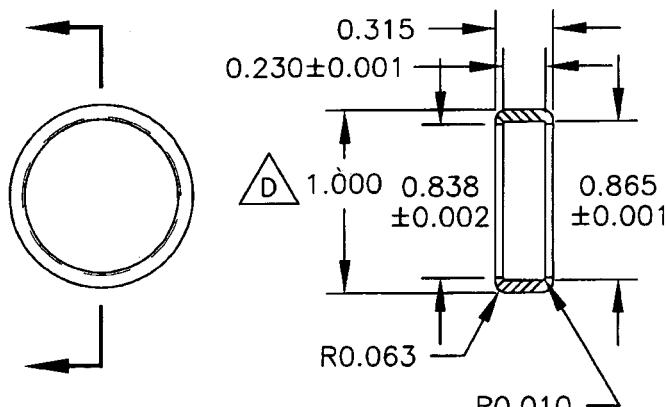
- 1) POSSIBLE SUPPLIER: KING BEARING P/N 6000-2ZJ/EM  
FAFNIR P/N 9100KDD
- 2) ALL DIMENSIONS ARE IN INCHES

**D3121-23 BEARING (SCALE 1:1)**

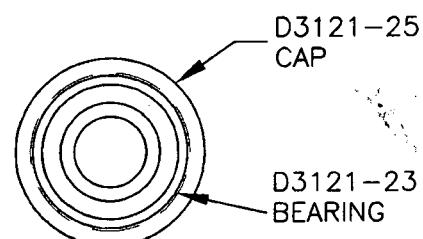
- 1) POSSIBLE SUPPLIER: SKF P/N 61900-2Z  
OR KML P/N 6900-2Z
- 2) ALL DIMENSIONS ARE IN INCHES

**D3121-21 BOLT (SCALE 1:1)**

- 1) MATERIAL: AISI 303 SS HEX, ANNEALED (REF DART SPEC. M303H0.500)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015

**D3121-25 CAP (SCALE 1:1)**

- 1) MATERIAL: DELRIN ROD, Ø1.25 (REF DART SPEC. M-DELRIN-R1.250)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES

**D3121-241 BEARING ASSEMBLY (SCALE 1:1)**